



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2574

Job Sheet 172065



Part No: D2574

Job Qty: 12 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/16/18	2/16/18	0.00	0.00	Start Up Machining		148/18/03/01
100	CNC Vertical Machining	12 pcs	2/17/18	2/17/18	1.21	18.75	HAAS 1		148/18/03/01
110	Mill Conv	12 pcs	2/17/18	2/17/18	0.00	1.50	Mill Conv 1		148/18/03/01
120	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC2		148/18/03/01
130	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC8		148/18/03/01
140	HandFinish	12 pcs	2/17/18	2/17/18	0.00	0.48	HandFinish1		148/18/03/01
150	Powdercoat	12 pcs	2/19/18	2/19/18	0.00	0.39	Powdercoat1		148/18/03/01
160	QC	12 pcs	2/19/18	2/19/18	0.00	0.00	QC3		148/18/03/01
170	Packaging	12 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3		148/18/03/01
180	QC21-SA	12 Ea	2/19/18	2/19/18	0.00	0.00	QC21		148/18/03/01

Part Op 100 - Program Batch No. 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-
Descriptions: Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
110 - Machine keyway as per dwg D2573 & D2574
150 - START TIME: 10:10 FINISH TIME: 10:10 CUT: 320° M13B 760 DAE 21 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	12	65	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		

Plex 2/12/18 12:57 PM Dart.Gagnon.Michelle



Container No: S046937



Part: D2574

Job No: 172065

Serial No/Batch: S046937

Revision: Rev.F

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/01/18

6	Saddle, Aft Inboard	0.490Inches	+ 0.020	0.510
			- 0.000	0.490
7	Saddle, Aft Inboard	0.257Inches	+ 0.005	0.262
			- 0.000	0.257
8	Saddle, Aft Inboard	0.375Inches	+ 0.005	0.380
			- 0.000	0.375
9	Saddle, Aft Inboard	0.490Inches	+ 0.020	0.510
			- 0.000	0.490
10	Saddle, Aft Inboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020	0.578
			- 0.000	0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010	1.375
			- 0.000	1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010	2.505
			- 0.000	2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010	4.129
			- 0.000	4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020	0.198
			- 0.000	0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040	3.250
			- 0.000	3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020	0.250
			- 0.000	0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005	0.312
			- 0.000	0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005	0.765
			- 0.000	0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020	0.372
			- 0.000	0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060	0.530
			- 0.000	0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020	0.635
			- 0.000	0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020	0.073
			- 0.000	0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020	1.520
			- 0.000	1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040	0.280
			- 0.000	0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

Plex 2/12/18 12:57 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 172 065
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 3

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.499	.501	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.125	4.124	4.124		
P	0.115	0.135		.133	.130	.125	.133		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.126	.126	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.229	3.230	3.230		
V	0.230	0.250		.242	.240	.241	.242		
W	0.115	0.135		.130	.132	.133	.133		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.363	.365	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.070	.070	.070	.068		
AD	0.240	0.260		.252	.252	.251	.251		
AE	1.500	1.520		1.500	1.500	1.500	1.500		
AF	0.115	0.135		.132	.130	.130	.133		
AG	0.240	0.280		.255	.252	.252	.255		
AH	0.240	0.260		.252	.250	.250	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBL DAS
Date: 18/03/03 39

Audited by: mmc
Date: 16/02/06

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 172065
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page: 2 of 3

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.499	.498	.498		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.132	.126	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.252	.252	.252		
S	0.115	0.135		.125	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.320	3.320	3.321	3.320		
V	0.230	0.250		.241	.241	.242	.241		
W	0.115	0.135		.133	.133	.133	.132		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.363	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.626	.625		
AC	0.053	0.073		.070	.068	.070	.067		
AD	0.240	0.260		.251	.252	.252	.252		
AE	1.500	1.520		1.500	1.500	1.500	1.500		
AF	0.115	0.135		.122	.126	.128	.125		
AG	0.240	0.280		.255	.252	.251	.255		
AH	0.240	0.260		.251	.253	.251	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBL
Date: 18/03/03

Audited by: m.m.c.
Date: 18/03/06

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
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DART AEROSPACE LTD	Work Order: 172065
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 3 of 3

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.498	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.124	.124	.124	.125		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.128	.127	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.230	3.230	3.230		
V	0.230	0.250		.242	.241	.241	.242		
W	0.115	0.135		.133	.132	.133	.133		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.365	.363	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.070	.070	.070	.070		
AD	0.240	0.260		.253	.252	.252	.252		
AE	1.500	1.520		1.500	1.500	1.500	1.500		
AF	0.115	0.135		.122	.122	.122	.122		
AG	0.240	0.280		.255	.252	.251	.251		
AH	0.240	0.260		.252	.252	.252	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBC
Date: 18/03/04

Audited by: mm
Date: 18/03/04

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B	02.09.27	Re-format; Added Rev. D	KJ	
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